Work Order ID 113670

February-24-14 10:01:06 AM

113670

Item ID: D2012-105
Revision ID:
Item Name: Arm (31.06)

Start Date: 2/24/14 **Start Qty:** 6.00 *6*
Required Date: 2/24/14 **Req'd Qty:** 6.00 *6*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLJ **Date:** 14-02-25 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2012-105	**Revision Nbr** E								
100	NC BRAKE	0.00				6			FF 14-04-07
100									
Brake NC		0.00							
Brake NC	**Memo** Punch to length as per Dwg D2012-105 & template D2012-105T1								
110	Small Fab	0.00				6			FF 14-04-07
110									
Small Fab		0.00							
Small Fab	**Memo** 1-Deburr								
		DAS 27 9-89							
120	QC5- Inspect part completeness to step on W/O	0.00				6			
120									
QC		0.00 14/4/7							
Quality Control	**Memo**								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M176878 **Memo** START TIME: 8:55 OVEN TEMPERATURE: 390° FINISH TIME: 9:25	0.00 0.00				6	0	14-4-9.	DAS 34 9-89
140 *140* QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				6			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: ST227 **Memo**	0.00 0.00				6			DAS 33 9-89 14-04-09

DAS 27 9-89 14/4/9

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DART AEROSPACE

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QC: _____ **Date:** _____

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Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160						MW	14-04-11		
QC	**Memo**	0.00							
Quality Control									

MF
14-4-10

DQA: _____ Date: _____

DART AEROSPACE

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☐ Wrong Stock Pulled

☐ Other

Picklist Print

February-24-14 10:01:06 AM

Work Order ID: 113670

113670

Parent Item: D2012-105

D2012-105

Parent Item Name: Arm (31.06)

Start Date: 2/24/14 **Required Date:** 2/24/14

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:I02.04.03Added Inspect level 3NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	219.1999	2.6254	16.58147			

M304TR0.500W.035

304 RD Tube .500 x .035W

**

FF 14-04-07

Location	Loc Qty	Loc Code	
MAT017	219.1999		
125513	16.1999		
m126922	3		
m128084	200		16.581

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DART AEROSPACE LTD

Description: ARM Work Order: 113670

Inspection Drawing: D 2012-105 Rev: E Part Number: D 2012-105

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
31.9	± 0.030	31.9	V		S Fab 07	
31.06	± 0.030	31.06	V		S Fab 07	

Measured by: FF
Date 14-04-07

Checked By: DAS 36 9-89
Date 14/04/07

QC inspector: DAS 27 9-89
Date 14/4/7

Engineering Approval (*if necessary*)
Date